

Patent Abstracts of Japan

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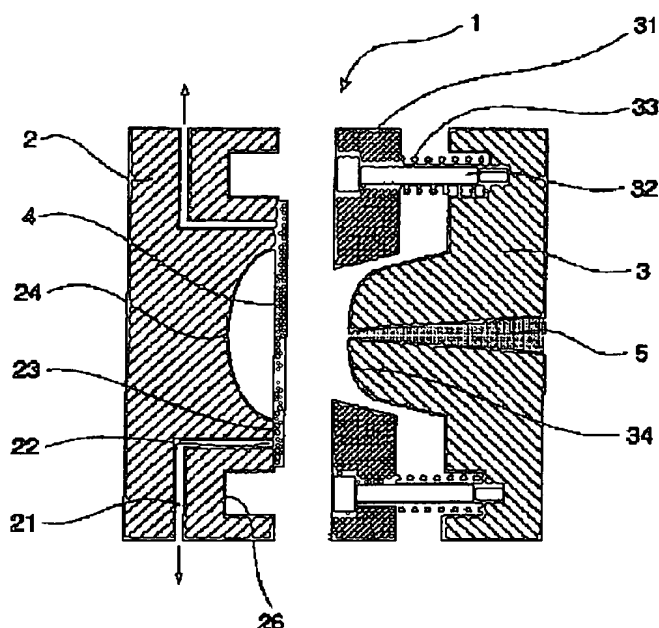
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APPLICANT : DAINIPPON PRINTING CO LTD;

INVENTOR : KOBIYAMA MITSUYUKI;

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TITLE : DECORATIVE MOLDED PRODUCT
AND IN-MOLDING METHOD THEREOF



ABSTRACT : PURPOSE: To integrate even a decorative sheet hard to extend with the surface of a molded product without generating wrinkles or breakage by fixing the decorative sheet to the parting surface of a female mold by the stripper plate provided to a male mold and clamping the male and female molds while stretching the decorative sheet by the molded product forming surface of the male mold to perform injection molding.

CONSTITUTION: A stripper plate 31 is arranged to a male mold 3 by a support rod 32 and energized toward a female mold 2 by a spring 33. A spot facing 26 is provided to the part of the female mold 2 corresponding to the support rod 32. A decorative sheet 4 is preparatorily fixed to the parting surface 23 of the female mold by the suction force from the vacuum hole 22 of the female mold 2. In a clamping process, the strip plate 31 comes into contact with the decorative sheet 4 prior to the molded product forming surface 34 of the male mold 3 to fix the decorative sheet 4 to the parting surface 23 of the female mold 2. Subsequently, the molded product forming surface 24 of the male mold comes into contact with the decorative sheet 4 to stretch the sheet 4 and, after the completion of mold clamping, a molten resin is injected.

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